

Date: Wednesday, 21/01/2009 7:37:40 AM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: EXTENSION TUBE ADJUSTMENT
<b>Job Number</b>	: 44971		
<b>Estimate Number</b>	: 12073		
<b>P.O. Number</b>	:	<b>Part Number</b>	: PB6743001293
<b>This Issue</b>	: 21/01/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: B6743001 PAGE38
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 41882	<b>Drawing Revision</b>	: B1
<b>Written By</b>	:	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	: <u>MF 09-01-21</u>	<b>Due Date</b>	: 27/01/2009
<b>Comment</b>	: Est. A 05.08.29 New issue KJ/JLM	<b>Qty:</b>	5
		<b>Um:</b>	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M7075T6R2000	7075 RD bar 2.00
	<b>Comment:</b> Qty.: 0.1575 f(s)/Unit Total : 0.7875 f(s) Material: 7075-T6511 Bar Ø2.00 (QQ-A-200/11) (M7075T6R2.000) Folio Rev: _____ Dwg Rev: _____ Identify for B67-43001-293 Batch: <u>M108595</u>	
		<u>09/01/25</u> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">5 pcs</span>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
	<b>Comment:</b> HARDINGE CNC LATHE SMALL Turn as per Folio FA 552 & Dwg B67-43001 Test fit on knurling Jig DT9423	
		<u>09/01/25</u> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">5 pcs</span>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>09/01/25</u> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">5 pcs</span>
4.0	LATHE CONV.	CONVENTIONAL LATHE
	<b>Comment:</b> CONVENTIONAL MILLING MACHINE Knurl as per Dwg B67-43001 using 1.200" pitch knurling wheels Using DT 9423	
		<u>09/02/10</u> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">5</span>
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>09/02/10</u> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">5</span>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-293 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: D Date: 07/02/19

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>44971</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/02/10</u>	<u>4.0.</u>	first part diameter of 2.00 $\pm$ .030" was 1.947. R.C. when inserting the first part it miss a washer on the ladder so the inserting was <del>over</del> overlapping. machine the diameter and do the inserting again. operator error.		Acceptable Finish i. deviation.	<u>JS</u> <u>07/04/10</u>	<u>JS</u> <u>07-02-10</u>	<u>P</u> <u>07.02.10</u> <u>per</u> <u>081042</u>	<u>JS</u> <u>07-02-10</u>
						<u>JS</u> <u>07-02-10</u>		<u>JS</u> <u>07-02-10</u>

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EXTENSION TUBE ADJUSTMENT

Job Number: 44971

Part Number: PB6743001293

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 09/02/10

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF

09-02-11

(X5)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask threaded section and inside bore

START TIME:

8:10am

OVEN TEMPERATURE:

320°C

FINISH TIME:

8:40am

MF

09-02-12

(X5)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ

09/02/17

(5)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

09/04/15

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/19

Job Completion



MF

09-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

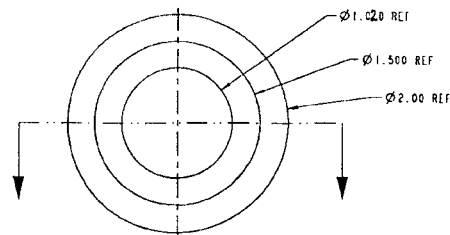
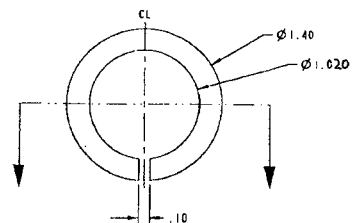
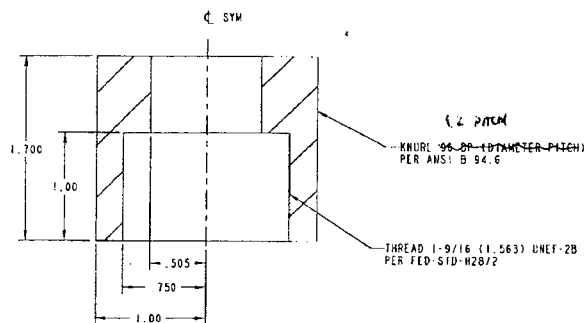
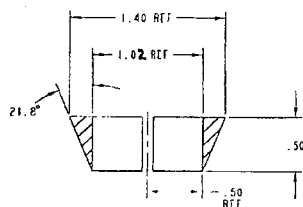
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
# 46-11-20

126717



① -291 CLAMP BUSHING   
JLM  
MATL: 6061-T6, 00-A-200/8  
SCALE 2.000

① -293 EXTENSION TUBE ADJUSTMENT FITTING   
JLM  
MATL: 7075-T6511, 00-A-200/11  
SCALE 2.000

PREMIER AVIATION, INC.  
9001 Aviation Parkway, Grand Prairie, Texas 75050  
DATE: 0001-10-01  
D: OSUV8  
B67-43001  
SCALE: 1:1  
SHEET: 32 OF 45

ORIGINAL